

Date: Wednesday, 22/04/2009 1:52:59 PM
 User: Melanie Fauteux

Process Sheet

Seq. f.
 Page

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 47380 - 2

Estimate Number : 13852

P.O. Number :

This Issue : 22/04/2009 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : SMALL /MED FAB

Previous Run : 47233

Part Number : D35704

Drawing Number : D3570 REV D PRELIM

Project Number : N/A

Drawing Revision : D PRELIM

Material :

Due Date : 23/04/2009

Qty: 1 Um: Eac

Written By :

Checked & Approved By :

Comment : Est Rev:A New Issue 09.04.14 EC verified by:DD

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.2982 sf(s)

6061-T6 .125 Sheet

Batch: 110067

1B9-4-22

1B9-4-24

Grain must be Along 4.63**

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: PRE

Prog Rev: 2im

1B9-4-22

1B9-4-24

2-Deburr if necessary

1B9-4-22

1B9-4-24

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

ENGINEERING
APPROVAL

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FF 09-04-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/03	S.O	Found @ inspection that all 4 parts were bent too short. Day ask for 390 messer About 3.810"	09.04.23 Poe 051 042	Scrap and Destroy Qty 4 110660 Rephr B2 11062	FF 09.04.23 #3 9.4.23	J 09/04/04	09.04.23 Poe 051042	S alochs
		R.C.		AND re Bend.				

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47380

Part Number: D35704

Job Number:



LAST PAGE
(PB) →

Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

FF 09-04-24 (2) (4)
FF 09-04-23

3-Drill as per Dwg D3570 Using Dt8946

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09.04.24 / S orley/24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMO/BR

(x2)
09/04/24

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:50
320°
11:20

BR 09-04-24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S orley/24 (x2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

GA

CMF 09-04-24

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/04/24

Job Completion



POSITIVE RECALL
EFFECTIVE
RELEASED

AUTH

DATE

09-04-24
09-04-24
09-04-24
09-04-24

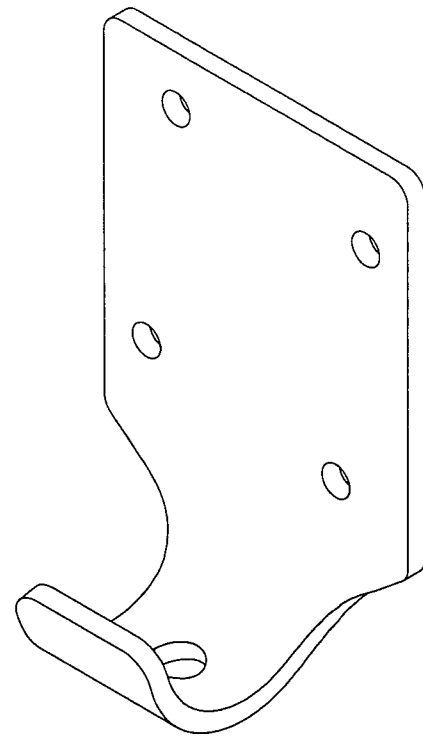
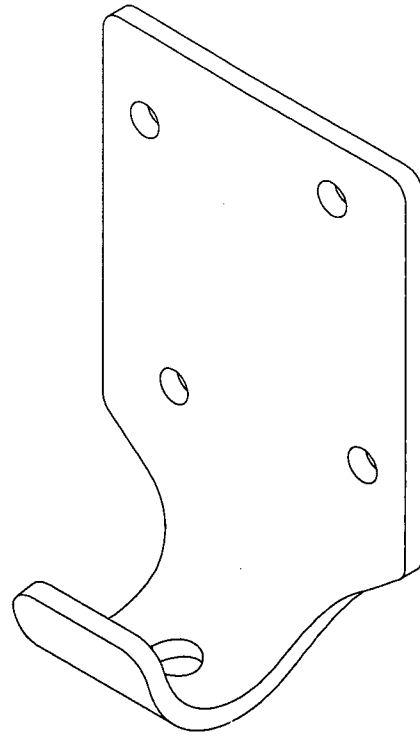
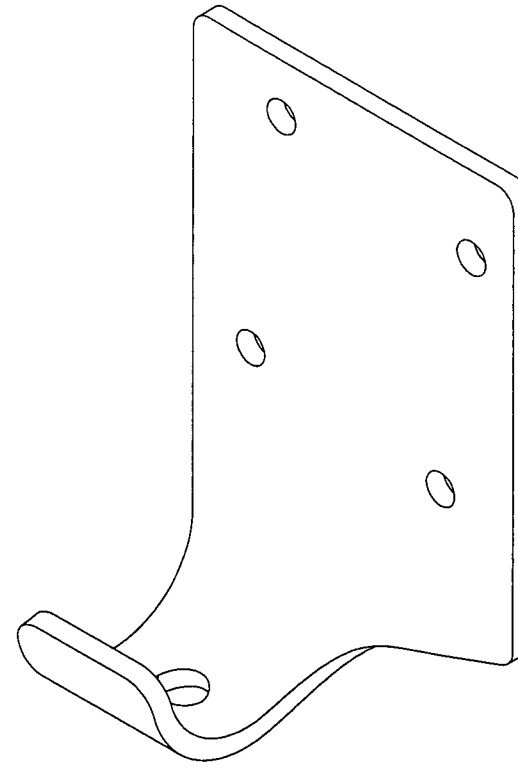
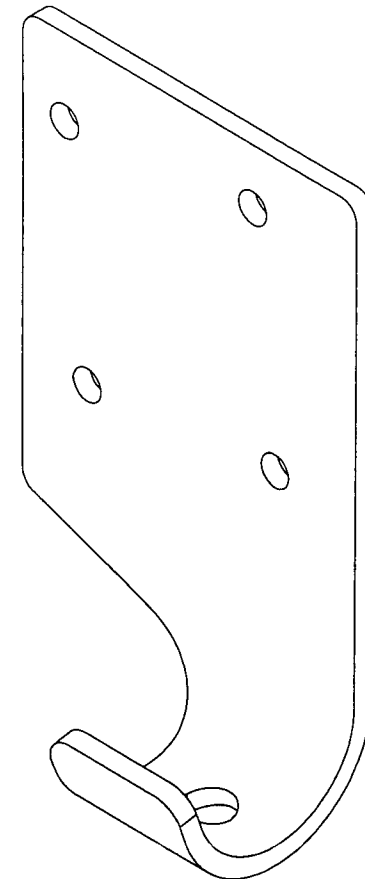
47 380

D3570-4

Page 1 of 1

☒ **First Article** ☐ **Prototype**

Measured by: <u>IB</u>		Audited by: <u>S</u>		Prototype Approval: <u>A</u>	
Date: <u>9-4-24</u>		Date: <u>02/04/24</u>		Date: <u>04.04.24</u>	
Rev	Date	Change			
A		New Issue			
				Revised by	Approved
				KJ/JLM	

**D3570-1 BRACKET****D3570-2 BRACKET****D3570-3 BRACKET****D3570-4 BRACKET**

47380

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

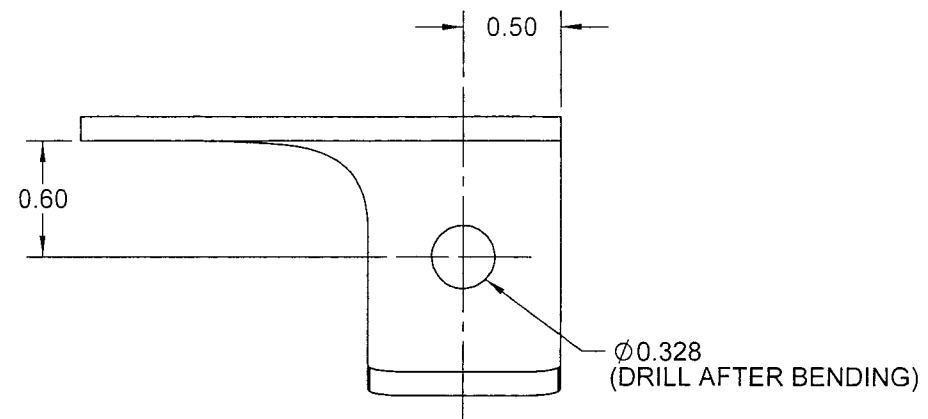
**PRELIMINARY
ISSUE**
AJS 09.04.22

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.04.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

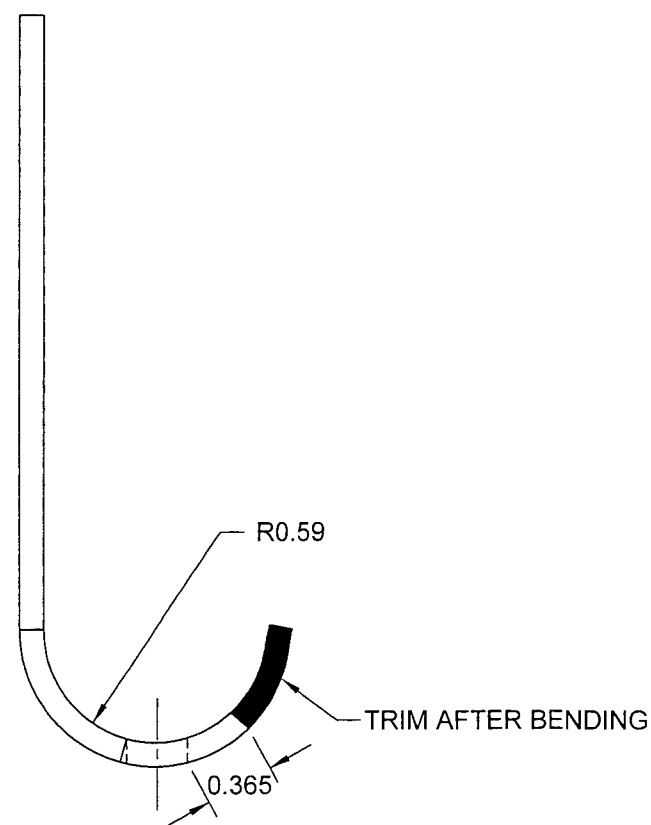
D

D



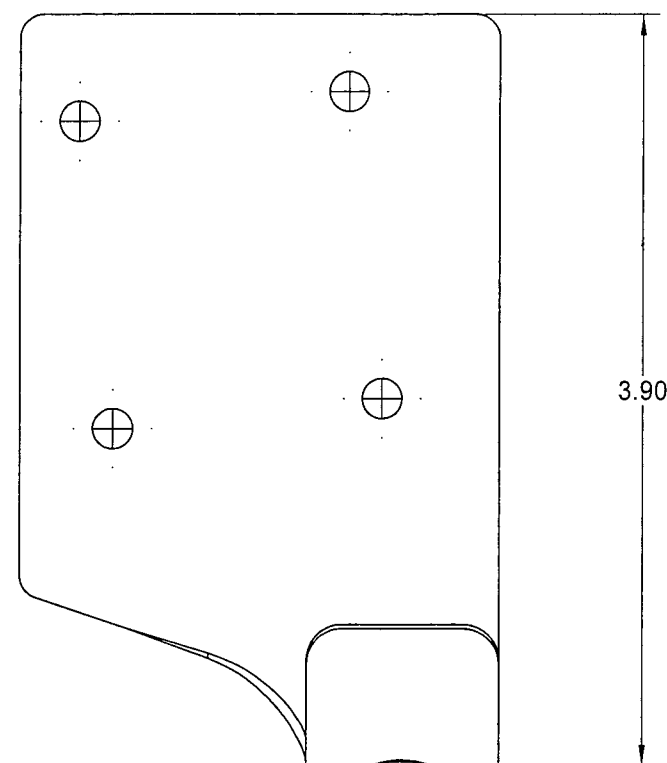
C

C



B

B



47380

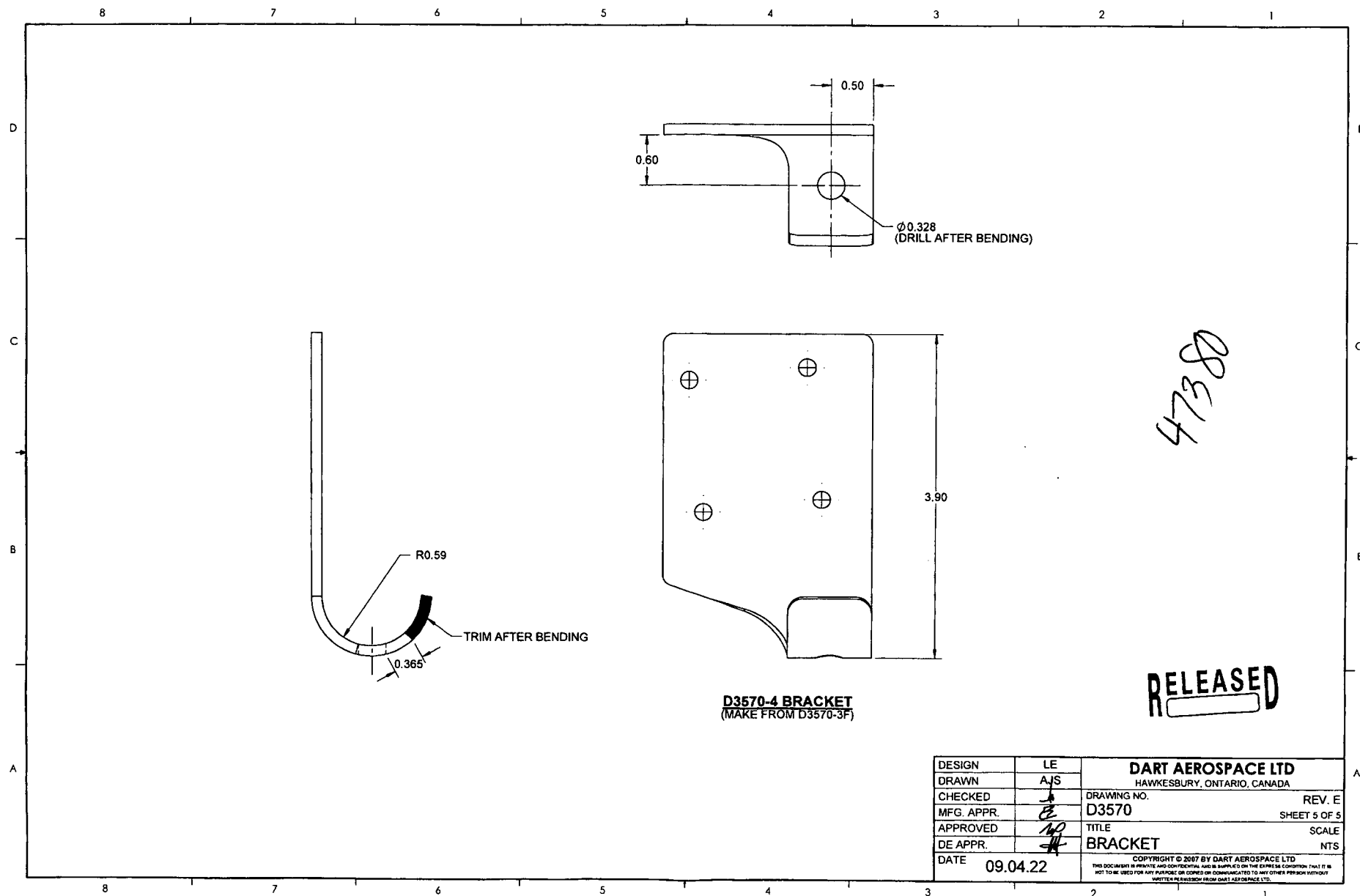
D3570-4 BRACKET
(MAKE FROM D3570-3F)

**PRELIMINARY
ISSUE**
AJS 09.06.22

DESIGN	4E	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3570	REV. E SHEET 5 OF 5
MFG. APPR.		TITLE BRACKET SCALE NTS	
APPROVED			
DE APPR.			
DATE	09.04.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

A



D3570-4 BRACKET
(MAKE FROM D3570-3F)

RELEASED

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.04.22	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	